

Date: Monday, 5/1/2006 3:45:54 PM  
 User: Kim Johnston

## Process Sheet

|                                    |  |                           |                    |            |
|------------------------------------|--|---------------------------|--------------------|------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services                                | <b>Drawing Name</b> :     | SKID TUBE ASSEMBLY |            |
| <b>Job Number</b> :                | 26867A   |                           |                    |            |
| <b>Estimate Number</b> :           | 10023  |                           |                    |            |
| <b>P.O. Number</b> :               | N/A  | <b>Part Number</b> :      | D205634041         |            |
| <b>This Issue</b> :                | 5/1/2006   | <b>Drawing Number</b> :   | D2580 REV C        |            |
| <b>Prsht Rev.</b> :                | NC   | <b>Project Number</b> :   | N/A                |            |
| <b>First Issue</b> :               | 5/1/2006   | <b>Drawing Revision</b> : | C                  |            |
| <b>Previous Run</b> :              | 25954A   | <b>Material</b> :         | N/A                |            |
| <b>Written By</b> :                | <i>See Comment Below</i>   |                           | <b>Due Date</b> :  | 5/20/2006  |
| <b>Checked &amp; Approved By</b> : | <i>06.05.02</i>  |                           | <b>Qty:</b>        | 1 Um: Each |
| <b>Comment</b> :                   | Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ |                           |                    |            |
|                                    | Est Rev. O 06.02.28 Added paperwork EC                             |                           |                    |            |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |           |                        |
|-----|-----------|------------------------|
| 1.0 | D25001190 | Ext'n -I' Beam Tube 4" |
|-----|-----------|------------------------|



**Comment:** Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

| Qty | Part Number | Description         | Batch          |
|-----|-------------|---------------------|----------------|
| 1   | D2500-1-190 | Skid Tube Extrusion | <i>B241669</i> |

*DP 06-6-5*

|     |    |                  |
|-----|----|------------------|
| 2.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



**Comment:** DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

*KB 06-05-10*

|     |       |         |
|-----|-------|---------|
| 3.0 | D2596 | 205 Web |
|-----|-------|---------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch         |
|-----|-------------|-------------|---------------|
| 1   | D2596       | 205 Web     | <i>B26750</i> |

*IT 06-06-05*

|     |                |                         |
|-----|----------------|-------------------------|
| 4.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



**Comment:** LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

*IT 06-06-05*

*DP 06-6-5*

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      | 2    |                    |  |    |      |     |                                     |                          |  |

Part No:                      PAR #:            Fault Category:                      NCR: Yes No DQA:            Date:                     

QA: N/C Closed:            Date:                     

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 3:45:54 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 26867A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid *fm '06-06-050*

6-Countersink holes as per Dwg D2580 without cutting fluid *fm '06-06-050*

7-Deburr and blow out all chips from inside of tube *fm '06-06-050*

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *M101126*

Sikaflex expire date: *06-11-01*

Start Time: *3:15* *RT 06-06-05*

Fin Time: *06-06-06 10:15AM*

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per program D2580.C on CNC Bender and Folio FT009 *DP 06-06-06*

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2580 *DP 06-06-06*

2-Deburr ends after cutting. Remove alodine from around holes *fm '06-06-060*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*BE 06-06-120*

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3

Step

*B23060 BE 06-06-120*

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |                |  |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B      |  | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign &<br>Date |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 26867A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch                   |
|-----|-------------|-------------|-------------------------|
| 20  | D2579       | Spacers     | B 25977 BE 06-06-12 (1) |

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required. BE 06-06-12 (1)

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M 100660

BE 06-06-12 (1)

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579 side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M 100660

BE 06-06-12 (1)

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

DP

5-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web. Deburr

DP 06-06-13

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

IT 06-06-14

7-Drill pilot holes for aft cap using DT 8215Open holes to #6 Drill bit. Deburr

IT 06-06-14

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

IT 06-06-14

11.0

QC5/9

WELD INSPECTION



PD 06-06-15 (1)

Comment: WELD INSPECTION

Inspect weld and Counterbore work to Step 20

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

A.M 06-06-26 (1)

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 26867A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*Job 28 (1)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch         |
|-----|-------------|-------------|---------------|
| 1   | D2577-1     | Wearplate   | <u>B25137</u> |

15.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch         |
|-----|-------------|-------------|---------------|
| 1   | D2577-3     | Wearplate   | <u>B25171</u> |

16.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch         |
|-----|-------------|-------------|---------------|
| 1   | D2577-5     | Wearplate   | <u>B24199</u> |

17.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

| Qty | Part Number   | Description | Batch         |
|-----|---------------|-------------|---------------|
| 4   | ALS7-1032-130 | Inserts     | <u>M18293</u> |

18.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch         |
|-----|-------------|-------------|---------------|
| 44  | AN960JD10L  | Inserts     | <u>M18235</u> |

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Monday, 5/1/2006 3:45:55 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 26867A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 44  | AN3-4A      | Bolt        | M15369 |

20.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch             |
|-----|-------------|-------------|-------------------|
| 16  | D2594-3     | O-RING      | 25593<br>B BAWHOM |

21.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 16  | D2594-3     | Plug        | B24104 |

22.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: \_\_\_\_\_

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

24.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: \_\_\_\_\_

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |  |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |  |    |      |     |                                     |                          |  |
|      |      |                    |  |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: 130 Date: 06/06/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 3:45:55 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 26867A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: 11/06

M101193 SC 06/28/06

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 11/06

M101193 SC 06/28/06

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

M101193

26.0

QC5

INSPECT WORK TO CURRENT STEP



M 06 29



(1)

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

27.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/30  
u 06.06.29

Job Completion



| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date & initial all entries



|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2580                              | REV. C<br>SHEET 1 OF 2 |
| DATE<br>98.08.26              |                                | TITLE<br>205 SKIDTUBE ASSEMBLY                    | SCALE<br>NTS           |
| A                             | 96.09.16                       | NEW ISSUE   |                        |
| B                             | 96.12.02                       | AS MANUFACTURED                                   |                        |
| C                             | 98.08.26                       | REDRAWN, INCLUDED DEO 9094/9097                   |                        |

RELEASED  
98/09/17 DS

| QTY | Part Number   | Description       |
|-----|---|-------------------|
| X   | D2580-041   | SKIDTUBE ASSEMBLY |
| *   | D2500-1   | EXTRUSION         |
| 1   | D2596   | 205 WEB           |
| 1   | D2575   | AFT CAP           |
| 1   | D2576 - 3   | STEP              |
| 20  | D2579   | CROSS BOLT SPACER |
| 16  | D2594-1   | PLUG              |
| 16  | D2594-3   | O-RING            |
| 1   | D2577-1   | WEARSHOE          |
| 1   | D2577-3   | WEARSHOE          |
| 1   | D2577-5   | WEARSHOE          |
| 44  | ALS7-1032-130<br>or AKS7-1032-130<br>or AKS4-1032-130<br>or ALS4-1032-130 | INSERT            |
| 46  | AN3-4A  | BOLT              |
| 46  | AN960JD10L  | WASHER            |

# 00.08.28  
UP 00.08.28

EFFECTIVE DEOS  
98/12/14  
DEO 9124  
DED 9183

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26867A

DETAIL B  
SCALE 5:24

#00 08.78  
D2576-3 LP 00 08.78

GRIND FLUSH (4 PLACES)

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

D2576 STEP

X

Diagram illustrating the installation of a dome cap. The cap is secured by two AN3-4A bolts (1) and AN950J10L washers (2). The cap is labeled D2575. The installation requires drilling prior to installation at two places. The cap is sealed with SIKAFLEX-241.

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SUBJECT TO AMENDMENTS  
WITHOUT NOTICE  
WORK ORDER  
NO. 20867A  
D2596 WEB (R)  
A52-1032-130 (R)  
CYP 44 PLAC

AFTER PERFORM  
1. CHA  
2. INSE  
3. WEL

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH.
4. C-BORE D2579 SPACER TO  $\phi 0.437$  X 1.00 DEEP

[illegible]

0.5

1.5

1.5

1.5

D

P

P

P

P

P

P

P

P

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

1.5

1.5

1.5

1.5

REFER TO DETAIL C

D2577-3

D2577-5


D2577-1

8

AN3-4A BOLT (1)  
AN96QJ10L WASHER (1)  
(44 PLACES)

|                              |                                |            |
|------------------------------|--------------------------------|------------|
| DESIGN<br><i>[Signature]</i> | DRAWN BY<br><i>[Signature]</i> | <b>DAR</b> |
|------------------------------|--------------------------------|------------|

RELEASE  
98/09/17 DS

|                       |                                |   |
|-----------------------|--------------------------------|---|
| DESIGN<br><i>DAH</i>  | DRAWN BY<br><i>CP</i>          |  <b>DART AEROSPACE LTD</b><br>MISSISSAUGA, ONTARIO, CANADA |
| CHECKED<br><i>DAH</i> | APPROVED<br><i>JS</i>          |   |
| DATE<br>98.08.26      | DRAWING NO.<br>D2580           | REV. C<br>SHEET 2 OF 2  |
|                       | TITLE<br>205 SKIDTUBE ASSEMBLY | SCALE<br>1:24   |